Work Order ID 67189

Wednesday, March 09, 2011 3:07:42 PM



Page 1

Item ID:

D3479-3

Accept

Setup Start

Revision ID:

Item Name: Tab, 99 degrees

Start Date: Required Date: 3/18/2011

3/9/2011

Start Qty: 6.00

Req'd Qty: 6.00

Cust Item ID: Customer:

Reference:

Approvals:

Date://-03

Date:

Tooling:

SPC (Y/N):

Date: Date: Run

Start

Stop

Stop

Sequence ID/ Work Center ID Operation

Description

Set Up/ **Run Hours** Tool ID

Tool # Plan

Code

Accept **Qty**

Reject Qty

Reject Number

Insp. Stamp

Draw Nbr

Revision Nbr

D3479

Rev B

SHEAR

Shear Shear

100

Cut Flat pattern .500" X .700" as per Dwg D3479

110

Small Fab

Small Fab

Small Fab

Memo

Memo

0.00

0.00

1-Deburr

120

Brake NC Brake NC

NC BRAKE

Memo

1-Form as per Dwg D3479

0.00

0.00

=7m/l 11/03/10

Dart	Aeros	pace	Ltd
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	•								
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									}
Part No:		PAR #:	PAR #: Fault Category: N				A:	Date: _	
				າ:	QA: N/C Closed: Date:				
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NCF	R)			
DATE		Description of NC		verii			Approval	Approval	
DATE	SIEP	STEP Description of NC Section A		Action Description Chief Eng	ption Sign & Date		ion C	Chief Eng	QC Inspector
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Work Order ID 67189

Wednesday, March 09, 2011 3:07:42 PM



Page 2

Item ID:

D3479-3

Accept

Setup Start

Stop



Revision ID:

Item Name:

Tab, 99 degrees

Start Date:

3/9/2011

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____

Date:

Tooling:

Date:

Date:

Run

Start

Stop



Required Date: 3/18/2011

Date:

SPC (Y/N):

Tool ID

Tool # Plan Code

Reject Accept Qty

Insp.

Sequence ID/ **Work Center ID**

130

QC

Quality Control

Operation **Description**

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

0.00

0.00

Qty

Reject Number Stamp

140

Packaging Packaging

Memo

Memo

0.00 0.00

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

0.00

Memo

0.00

MF 11-03-14

150

Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	DQA: Date:		
Reso		esolution:	Disposition	on:	_ QA: N/C C	losed:	,	Date: _	
NCR:			WORK ORD	DER NON-CONFORM	ANCE (NCF	₹)			
DATE	STEP	Description of NC Section A	Initial Action Description		Section B tion Sign &		cation ion C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date				
							. 4		

Picklist Print

Wednesday, March 09, 2011 3:07:59 PM

Work Order ID: 67189

Parent Item:

D3479-3

Parent Item Name: Tab, 99 degrees



Start Date: 3/9/2011

Required Date: 3/18/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

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IPP Rev:A New Issue 06-02-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA		Purchased	No		100	sf	46.3100	0.5	3 M.	1	11/0	3/10

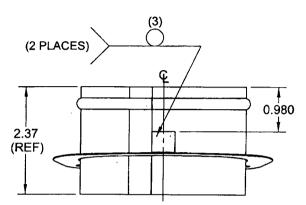
Location Loc Qty Loc Code MAT20 46.31 15.06 112885 31.25

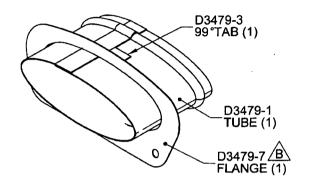
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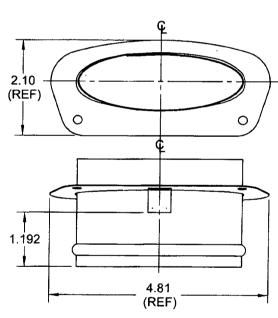
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W/O:			WO	RK ORDER CHANG	ES		•		
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		PAR #:							
	Re	esolution:						Date:	
NCR:		·	WORK ORDE	ER NON-CONFORMA	ANCE (NCI	₹)			
DATE	STEP	Description of NC		Corrective Action Section B		Verifi	cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		tion C	Chief Eng	QC Inspector
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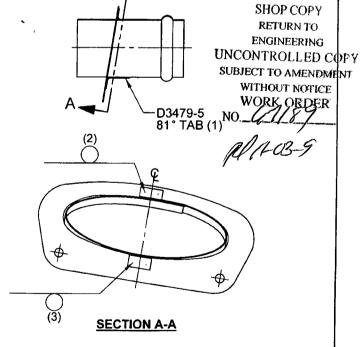


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CHECK		APPROVED	DRAWING NO.	REV. B	
PH M		M	D3479	SHEET 1 OF 4	
DATE			TITLE	SCALE	
08.12.19			INLET ADAPTER	1:2	
Α	06.01.19		NEW ISSUE		
B 08.12.19			CORRECT TYPO ON SHT1; ADD TOL ON SHT2 MATL SPEC WAS MIL-S-5019		









D3479-041 INLET ADAPTER

NOTES:

1) SPOT WELD PER DART QSI 018

2) FINISH: NONE
3) IDENTIFY WITH DART P/N D3479-041 USING

FINE POINT PERMANENT INK MARKER
4) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
Х	D3479-041	INLET ADAPTER
1	D3479-1	TUBE
1	D3479-3	99 DEGREE TAB
1	D3479-5	81 DEGREE TAB
1	D3479-7	FLANGE

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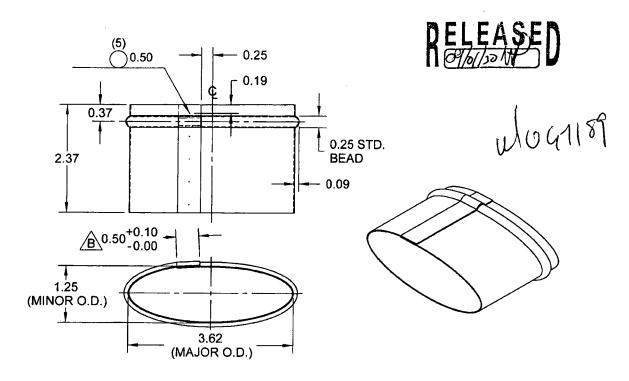
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DATE	STEP	PRO	OCEDURE CHA	NGE	В	У	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No:		PAR #: Fault Category: N					NCR: Yes No DQA: Date:						
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	OTED	Description of NC		Corrective Action Section B			Verification		Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng			Sign & Date		on C	Chief Eng	QC Inspector			
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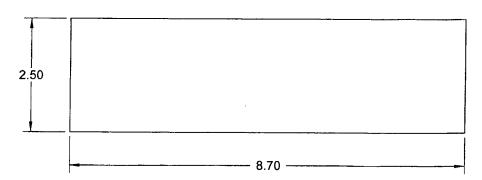
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DATE		TITLE	SCALE
08.	12.19	INLET ADAPTER	1:2



D3479-1 TUBE



D3479-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) SPOT WELD PER DART QSI 018
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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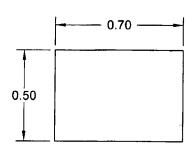
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Resolution:			Disposition	QA:	N/C CI	Date: _				
NCR:			WORK ORDE	R NON-CONFOR	MANCE	(NCR	(1)			,
DATE	STEP Description of NC Section A		Corrective Action Section Initial Action Description Chief Eng Chief Eng			Sign & Date		ication tion C	Approval Chief Eng	Approval QC Inspector
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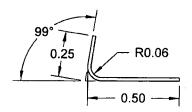
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DATE		TITLE	SHEET 3 OF 4
1	12.19	ADAPTER INLET	2:1

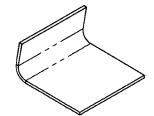


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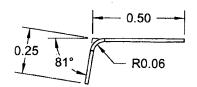
D3479-3F FLAT PATTERN

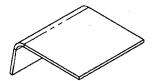
1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)





D3479-3 99 DEGREE TAB (MAKE FROM D3479-3F FLAT PATTERN)





D3479-5 81 DEGREE TAB (MAKE FROM D3479-3F FLAT PATTERN)

NOTES:

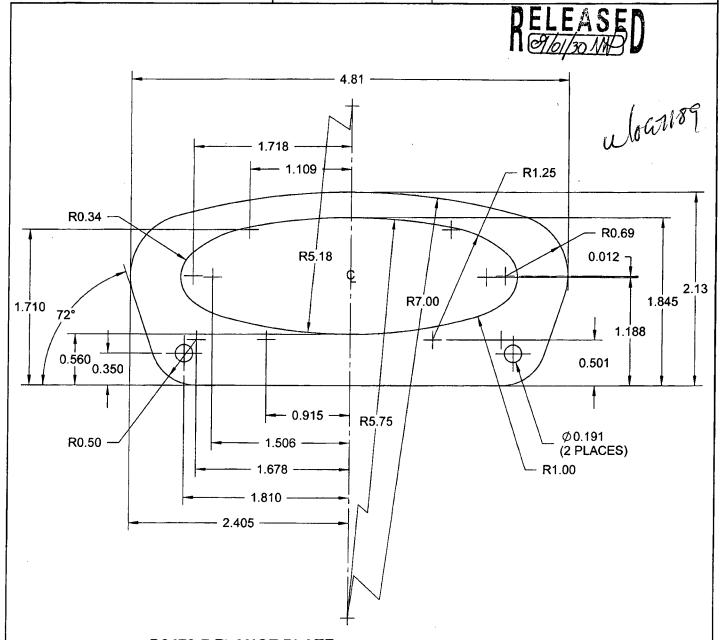
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Ae	ospace L	.td							
W/O:			WO	RK ORDER CHANG	ES				
DATE STEP		PRO	DCEDURE CHANGE By			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Resolution:		Disposition	_ QA: N/C (Closed:	Date:				
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NC	R)			
		Description of NC			on B	Verif	ication	Approval	Approval
DATE	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	000	tion C	Chief Eng	QC Inspector	



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	DESIGN	DRAWNBY	DART AEROSPA HAWKESBURY, ONTARI	
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-	PH		D3479	SHEET 4 OF 4
	DATE		TITLE	SCALE
	08.1	12.19	ADAPTER INLET	1:1



D3479-7 FLANGE PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) PART IS SYMMETRICAL ABOUT CENTERLINE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	DCEDURE CHA	NGE		Ву	Date	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	:	PAR #:	Fault Cate	gory:	NCF	: Yes I	No DQ	A:	Date:		
Resolution:			Disposition: C			N/C Cld	Date: _				
NCR:		·	WORK ORD	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC Section A	Corrective Action Section					ication	Approval	Approval	
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